Wednesday, 5/10/2006 9:20:01 AM User: Kim Johnston Customer Job Number **Estimate Number** P.O. Number This Issue Prsht Rev. First Issue Previous Run Written By Comment **Additional Product** Job Number: Sea. #: 1.0

**Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : STOP : 27050A : 10731 : NIA Part Number : D23243 S.O. No. : N/A : D2324 REV. C : 5/10/2006 **Drawing Number** : NC : N/A Project Number : N/A : SMALL /MED FAB : C Type **Drawing Revision** : NIA : 25820A Material OMMENT RAW Due Date : 5/30/2006 Qty: 20 Um: Each Checked & Approved By Reformat; Incorporated D2324-3 & D2324-5 K : Est: J/RF Description: M6061T6B0750X00750 6061-T6 Bar .75" x .75" 0.5565 f(s)/Unit Total: 11.1300 f(s) Comment: Qty.: 6061-T6 Bar 0.75" x 0.75" Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8) (M6061T6B0.750x00.750) Batch: Mpg 442 (M6061T6B0.750x00.750) BAND SAW BAND SAW 2:0 Comment: BAND SAW Cut blanks: (0.75" x 0.75") x 5.75" Long Bar 3.0 Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio D2324-3 and Dwg D2324 2- Deburr and Tumble to remove sharp edges Identify as D2324-3 4.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 5.0 QC8 SECOND CHECK Comment: SECOND CHECK 06105118 90

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector				
			:								
						<u> </u>					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			Annroval	A		
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector		
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Part No:	PAR #:	Fault Category:	NCR:	Yes No DQA:	Date: <u>06/05/25</u>
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

Wednesday, 5/10/2006 9:20:01 AM Dat€: User: Kim Johnston **Process Sheet Drawing Name: STOP** Customer: CU-DAR001 Dart Helicopters Services Part Number: D23243 Job Number: 27050A Job Number: Seq. #: Description: Machine Or Operation: HAND FINISHING RESOURCE #1 HAND FINISHING1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 7.0 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 Comment: INSPECT ALODINE PACKAGING 1 PACKAGING RESOURCE 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 DC DOCUMENT CONTROL Comment: DOCUMENT CONTROL Inspection Level 21 CJae105125 Job Completion

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES								
DATE	STEP	1.	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector			
					·					

	WORK ORDER NON-CONFORMANCE (NCR)									
	Description of NC		Corrective Action Section B		Varification		Approval			
STEP	STEP Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Design Mgr	Approval QC Inspecto			
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	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial Design Mgr	STEP Description of NC Section A Initial Design Mgr Design Mgr Design Mgr	STEP Description of NC Section A Initial Design Mgr Design Mgr Design Mgr Design Mgr Date	STEP Description of NC Section A Initial Design Mgr Action Description Design Mgr Section C Section C	STEP  Description of NC Section A  Initial Design Mgr Design Mgr  Design Mgr  Design Mgr  Verification Section C Sec			

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	 Date:	
NOTE: Date & initial all entries				QA: I	N/C C	losed:	Date:	

DART AEROSPACE LTD	Work Order:	27050A
Description: Strut	Part Number:	D2324-3
Inspection Dwg: D2324 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+/-0.010	0.257				
Ø0.191	+/-0.010	0,191				
0.750	+/-0.010	.750				Mat thickness
0.375	+/-0.010	,373				
1.875	+/-0.010	1.873	-			
5.250	+/-0.010	5.249				
5.625	+/-0.010	3.625				
						,
						Ų
	,					

Measured by:	42	Audited by:	J.G.	Prototype Approval:	N/A
Date: (	36.05.17	Date:	06/05/17	Date:	N/A

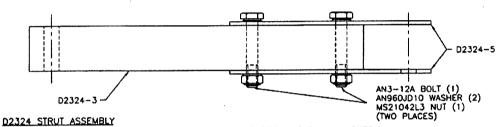
Rev	Date	Change		Revised by	Approved
_ A	04.06.10	New Issue	P/O D2324-1	KJ/JLM , ,	-1
В	06.03.08	Dwg Rev changed		KJ/JLM	911



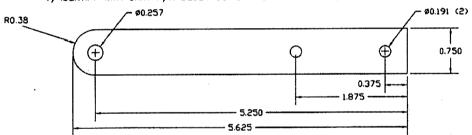
	DESIGN B W	ILLIAMS	DRAWN BY	DART AEROSPACE VICTORIA INTERNATIONAL AIRPORT,		
1	CHECK		APPROVED	DRAWING NO.	-644	REV. C
ı		#-	-#-	D2324	SHEET	1 OF 1
1	DATE	<u>.:15</u>		TITLE		SCALE
ı	04.1	2.14		STRUT		,
	Α		94.11.08	NEW ISSUE		
	В		96.05.07	UPDATE MATERIALS		
	_		044044	LICOLITE MOTEC		

RELEASED 04.12.16

04.12.14 | UPDATE NOTES C - 6.000(REF) -O 0



1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



02324 - 3

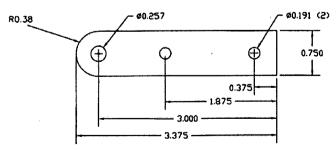
6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75 1) MATERIAL: (REF DART SPEC. M6061T6B0.750X00.750)

ACID ETCH AND ALODINE PER DART QSI 005 4.1 2). FINISH:

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED



D2324-5

AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) 1) MATERIAL: (REF DART SPEC. M304S16GA)

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 2) FINISH:

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE